

Profiled Milling Cutter Ø125 Z22

A2-040

The tool is ground with a profile wheel, the dressing is performed directly on the machine. By interpolation paths and CAM (radial relief) are calculated automatically. The below mentioned grinding time is based on a material removal of about 0.2mm.



1. Cycletime for Production

Workpiece: Diameter 125,8 mm, Z22 Material HSS									
Operations									
1 Probe	2000	80	200	150	150	2000	200	150	150
1 Dress							1	1	2
1 Raggio							32	32	32
1 Smusso									
1 Piano									
Used wheels		—	—	1	1	1	1	1	1
Grinding time [s]	20	60	960	45	60	20	960	45	60
Total cycle time	37 Min 10								

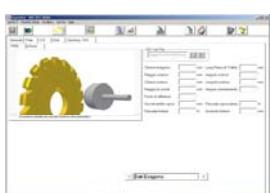
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1: Ø30 shank 6mm



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **GEMINI**dmr AWL

Control: Fanuc 31i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 5

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